

Work Order ID 152766

152766

Page 1

Monday, November 07, 2016 3:09:24 PM

Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205 Skidtube
 Start Date: 11/2/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/7/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21** Date: **NOV 10 2016** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2596	Rev D

100 Skidtubes 0.00
100
 Skidtubes Memo 0.13
 Skidtubes
 1- Cut D2500-3-100 to length: 99.5"
 2- Use Jig DT8093 to drill pilot holes #30
 3- Open to 0.630" diameter as per Dwg D2596
 4- Deburr

4 & 17-01-03
DT

110 Chemical Conversion Coat per QSI005 4.1 0.00
110
 HandFinish Memo 0.13
 Hand Finishing

(x4) & 2017/01/16
BEB

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.01
 Quality Control

DAS 03 9-89
DP
17-1-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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130

Identify as per dwg & Stock Location: **L600Z** 0.00***130***

Packaging

Memo

0.01

Packaging

(4) **17-1-20**

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.07

Quality Control

DAS
21
9-88

JAN 24 2017

JAN 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Monday, November 07, 2016 3:09:24 PM

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Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured No

100

Each

153.0000

1

4

D2500-3-100

Ext'n -I' Beam Web 4"

17-01-03T

Location

Loc Qty

Loc Code

LG

153

147804

153

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

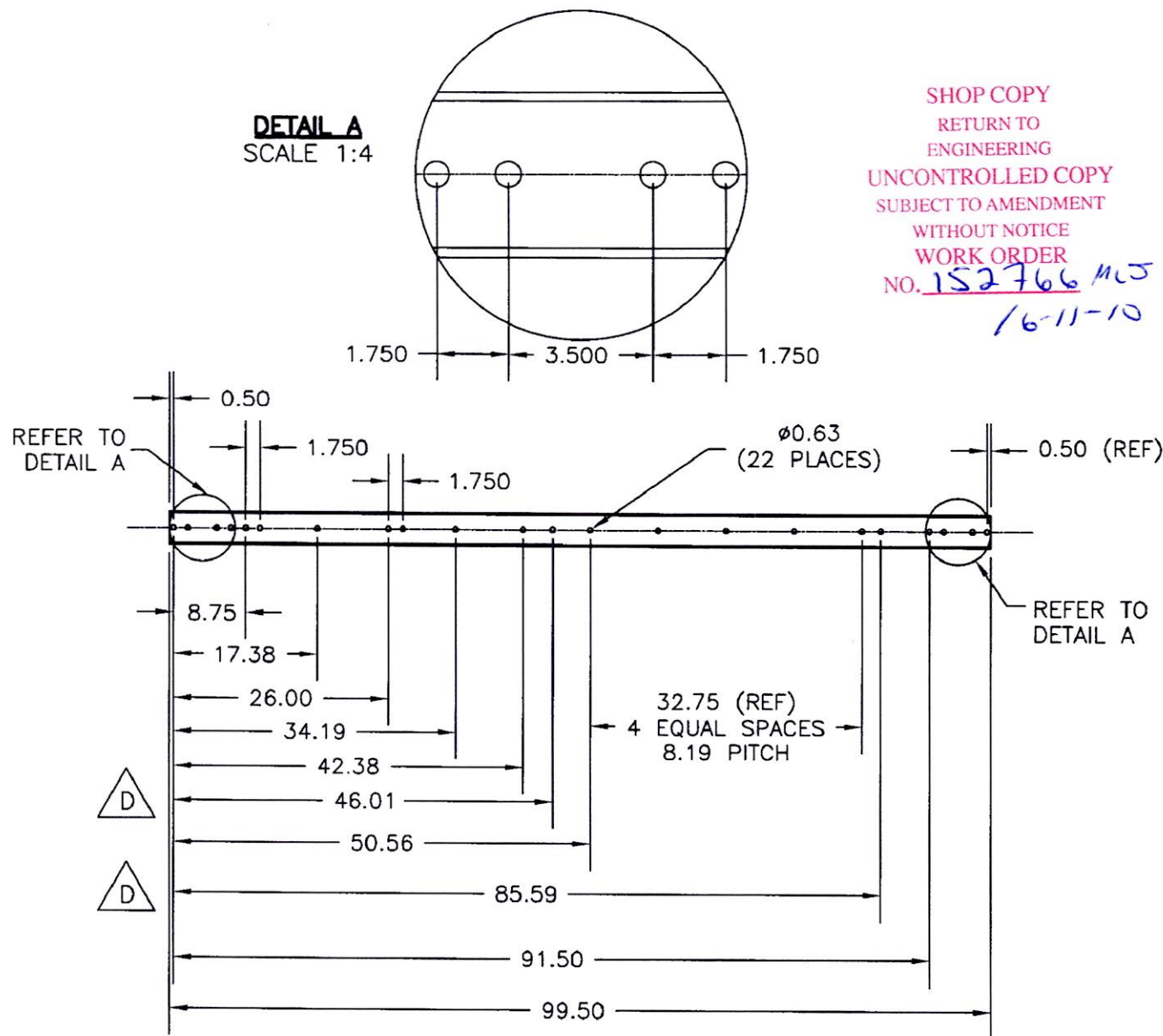
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Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART

RELEASED
07.06.28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152766 MJS
/6-11-10

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. D
04	04	DRAWING NO.	D2596	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	205 WEB	SCALE
07.04.17	07.04.17			1:20
A	96.09.16	NEW ISSUE		
B	97.07.23	$\phi 0.63$ HOLE WAS $\phi 0.56$		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		